

76969

Thursday, November 24, 2011 1:32:15 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/24/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 12/5/2011 **Req'd Qty:** 4.00

4

Customer:

Run Start *NR1*

Date: 11/24

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76969

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Thursday, November 24, 2011 1:32:15 PM

Item ID: D2671 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206 Narrow
 Start Date: 11/24/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/5/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180	Packaging								
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/21/23 (4) sf

MCT 12/02/24

12-02-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 24, 2011 1:32:20 PM

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Work Order ID: 76969

76969

Parent Item: D2671

D2671

Parent Item Name: Bearpaw, 206 Narrow

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	539.2000	2.7	10.8			
MUHMWB10									**		12-1-12		
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT018

539.2

10035

117321

74.6

117738

124.3

117819

99.3

118814

39

119145

202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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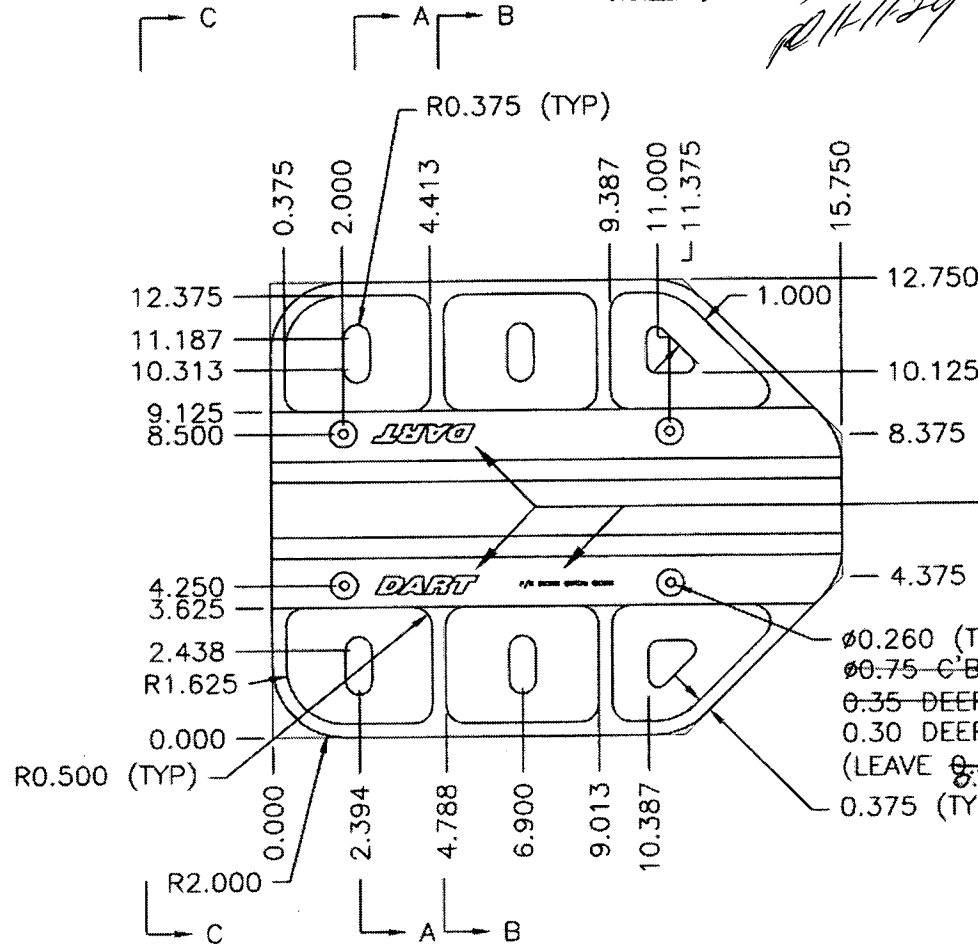
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NOTE: Date & initial all entries

SHOP COPY

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 70909
21/11/24

B1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

RELEASED
99.06.17 KE

EFFECTIVE DECS
9143

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	REV. B
DATE 98.05.19	TITLE BEARPAW	SHEET 1 OF 2
A 97.04.08	NEW ISSUE	SCALE 1:5
B 98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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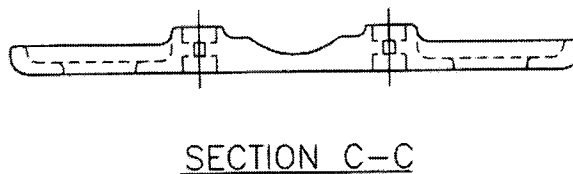
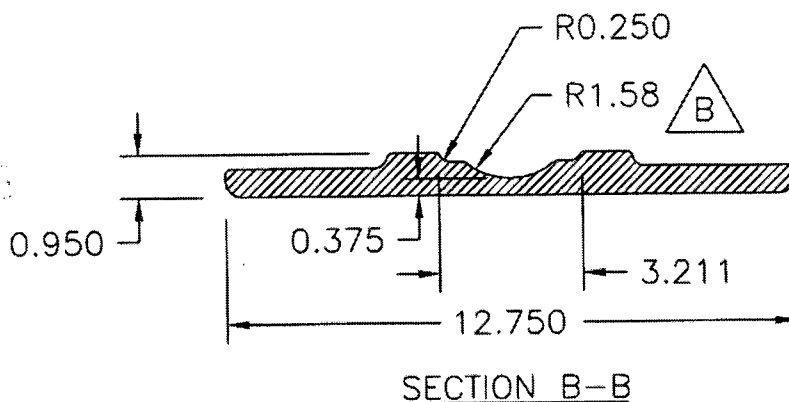
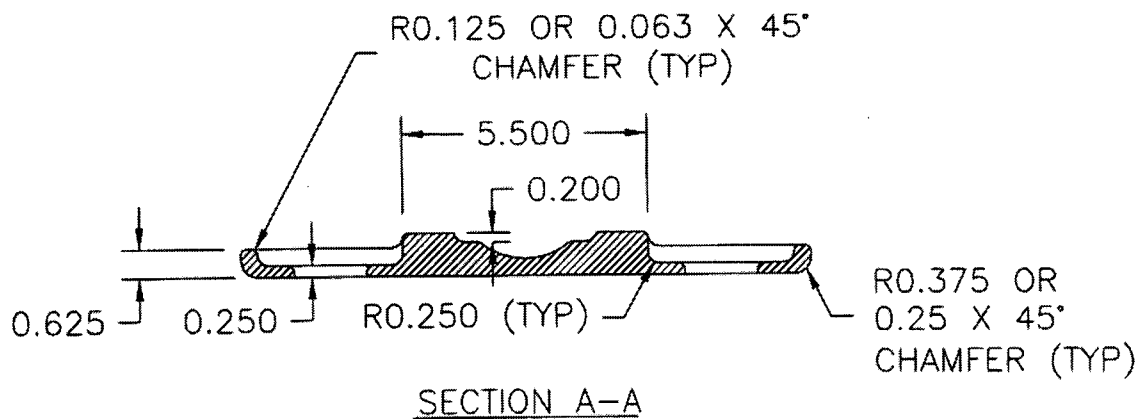
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

76969



W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	76909
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.053	✓		caliper	RT-04
B	5.500	+/-0.030	5.505	✓		"	
C	0.200	+/-0.030	.197	✓		"	
D	R0.250	+/-0.030	.250	✓		1" Rad gauge	RT-04
E	0.625	+/-0.030	.633	✓		caliper	
F	0.250	+/-0.010	.259	✓		1" mic	RT-01
G	0.950	+0.030/-0.010	.956	✓		caliper	
H	0.25 x 45°	+/-0.030	.258	✓		"	
I	0.375	+/-0.010	.384	✓		"	
J	12.750	+/-0.030	12.75	✓		tape	RT 10
K	Ø0.260	+0.005/-0.000	.260	✓		caliper	
L	Ø0.93	+/-0.030	.925	✓		"	
M	0.30	+0.030/-0.000	.308	✓		"	
N	4.250	+/-0.030	4.257	✓		"	
O	0.375	+/-0.030	.381	✓		"	
P	2.000	+/-0.030	2.001	✓		"	
Q	4.250	+/-0.010	4.255	✓		"	
R	9.000	+/-0.010	9.000	✓		"	CNC - 02
S	15.750	+/-0.030	15.75	✓		tape	

Measured by:	RT / RA	Audited by:	B.A	Prototype Approval:	N/A
Date:	12-02-21	Date:	12/02/21	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

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